

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023605**Date Inspected:** 07-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers & Handrail**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS2-1, OBG Bike Path Handrail components. Welder is identified as 201861. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS2-1, OBG Bike Path Handrail components. Welder is identified as 201861. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS2-1, OBG Bike Path Handrail components. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

Bay #9

NDT

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08981.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG Traveler Rails. The weld designations reviewed are as follow: 3014TR-002-003/004, 3016TR2-001/002.

Bay #5

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08979.

This QA inspector performed Mag Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG Traveler Rails. The weld designations reviewed are as follow: 3025TR1-001~011, 3022TR1-003-001~011.

Bay #1

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08979.

This QA inspector performed Visual Testing (VT) of approximately 100% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG Bike Path Handrails. The weld designations reviewed are as follow: NS-3(pp048, 050,016, 022, 040, 038.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey,Delbert	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
